

February-03-12 10:23:05 AM

Item ID: D3179-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Fwd Litter Tie Down

Stop *NS2*

Start Date: 03/02/2012 **Start Qty:** 4.00

4

Cust Item ID:

Required Date: 17/02/2012 **Req'd Qty:** 4.00

4

Customer:

Reference:

Approvals: Process Plan: M.L.J. Date: 12/02/03 Tooling:

Date:

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____

Date:

Stop ***NR2***

[illegible]

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 79792

79792

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 Item Name: Fwd Litter Tie Down
 Start Date: 03/02/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 17/02/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC8- Inspect parts - second check	0.00							
130									
QC	Memo	0.00				4	2		
Quality Control									
140	Chemical Conversion Coat per QSI005 4.1	0.00							
140									
HandFinish	Memo	0.00							
Hand Finishing									
150	QC3- Inspect Part Finish	0.00							
150									
QC	Memo	0.00				4x	4		
Quality Control									

4x 2 m-12/02/16

4x 4 m 12/02/16

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 Start Date: 03/02/2012 Start Qty: 4.00 ***4*** Cust Item ID:
 Required Date: 17/02/2012 Req'd Qty: 4.00 ***4*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum	0.00							
160									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 3:30	OVEN TEMPERATURE:							
	FINISH TIME: 4:00								
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									
180	Small Fab	0.00							
180									
Small Fab	Memo	0.00							
Small Fab	Assemble as per Dwg D3179								

4XJ M-f 12/02/21

4 BR 120222

EP 2/02/24 (4)

M 119480

32501

4:00

W/O:		WORK ORDER CHANGES					
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 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190 *190* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00		SS 12/02/24		(4)			
200 *200* Packaging Packaging	Identify as per dwg & Stock Location: <u>225</u> Memo	0.00 0.00							12/2/27 <u>SS</u>
210 *210* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							12/2/27 <u>SS</u>

12/2/27 (4)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

February-03-12 10:23:09 AM

Page 1

Work Order ID: 79792

79792

Parent Item: D3179-041

D3179-041

Parent Item Name: Fwd Litter Tie Down

Start Date: 03/02/2012

Required Date: 17/02/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP A1 03.01.09 Added Acid etch end alodine RF
IPP Rev:B Added Powder Coat 07-07-04 JLM
IPP Rev:C 08-12-10 add part list DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
NAS1149D0332J		Purchased		No		100	Each	1,739.000	3	12			
NAS1149D0332.J										**	EP 12/02/24		
Washer													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST298		1739							
				105793		12							
				110985		4							
				117087		89							
				118384		95							
				119042		539							
				119717		1000							
D2372		Manufactured		No		180	Each	0.0000	2	12	8		
D2372										**	EP 12/02/24		
Quick Release													
D2444		Manufactured		No		180	Each	13.0000	1	4			
D2444										**	EP 12/02/24		
Pip Pin Assembly													
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				GA		6							
				77689		6							80060
				ST014		7							(4)
				72147		7							

80060
(4R)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

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Work Order ID: 79792

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Parent Item: D3179-041

D3179-041

Parent Item Name: Fwd Litter Tie Down

Start Date: 03/02/2012

Required Date: 17/02/2012

Start Qty: 4.00

Required Qty: 4.00

D6201 Manufactured No

180 f

22.7400 1.0125 4.263158

D6201

"T" Extrusion

**

25 12-02-10

Location

Loc Qty

Loc Code

MAT004

10.74

57767

1.34

71208

9.4

MAT28

12

77491

12

MS21042L3

Purchased No

180 Each

5,123.000 1

4

MS21042L3

Nut

**

4.263

4.2/02/24

Location

Loc Qty

Loc Code

ST300

5123

117441

16

117885

32

118451

5

118927

3

119017

4657

119075

410

MS27039-1-13

Purchased No

180 Each

125.0000 1

4

MS27039-1-13

Screw

**

4

4.2/02/24

Location

Loc Qty

Loc Code

ST291

125

110844

25

119736

100

4

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DART AEROSPACE LTD		Work Order:	79792
Description: Fwd Litter Tie Down Bracket		Part Number:	D3179-1
Inspection Dwg: D3179	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/-0.030	1.001	/		Vern JL-3	
Ø0.242	+0.005/-0.001	.242	/		"	
R0.40	+/-0.030	.40	/		R-G	
0.375	+/-0.010	.368	/		Vern JL-3	
Ø0.191	+0.005/-0.001	.191	/		"	
1.00	+/-0.030	1.000	/		"	
1.70	+/-0.030	1.693	/		H-G	
4.00	+/-0.030	3.992	/		Vern JL-3	
1.50	+/-0.030	1.500	/		"	
0.750	+/-0.010	.750	/		"	
1.50	+/-0.030	1.500	/		"	
10.500	+/-0.010	10.500	/		Vern CNC-D2	
4.250	+/-0.010	4.250	/		"	
0.750	+/-0.010	.751	/		Vern JL-3	
1.000	+/-0.010	1.000	/		"	
12.00	+/-0.030	12.00	/		Vern CNC-D2	
1.00	+/-0.030	1.00	/		Vern JL-3	
8.00	+/-0.030	8.00	/		Vern CNC-D2	
Ø0.191	+0.005/-0.001	.191	/		Vern JL-3	
R0.37	+/-0.030	.375	/		R-G	
0.97	+/-0.030	.962	/		Vern JL-3	
1.86	+/-0.030	1.861	/			
Ø.750	+/-0.010	.750	/			
0.375	+/-0.010	.372	/		"	
2.875	+/-0.010	2.873	/		"	
0.500	+/-0.010	.500	/		"	
1.250	+/-0.010	1.250	/		"	
1.625	+/-0.010	1.625	/		"	
3.31	+/-0.030	3.313	/		"	

Measured by:	JL	Audited by:	an	Prototype Approval:	N/A
Date:	12-02-14	Date:	12/02/15	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.04.05	New Issue	KJ/DD	

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

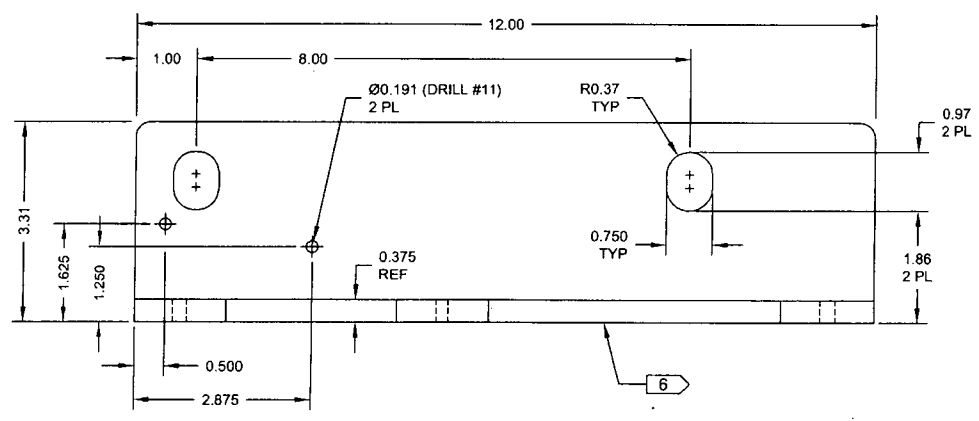
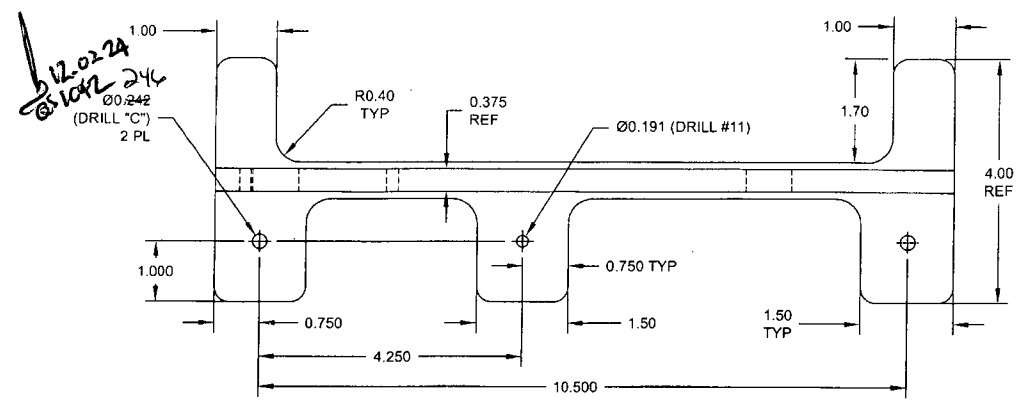
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79792



D3179-1 LITTER TIE DOWN BRACKET

NOTES:

- 1) MATERIAL: MAKE FROM D6201-012 EXTRUSION (6061-T6/T6511 PER QQ-A-200/8)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N D3179-1 USING FINE POINT PERMANENT INK MARKER ON THE BOTTOM FACE
- 7) WEIGHT: 2.3 lbs

DESIGN	BW	DART AEROSPACE LTD	
DRAWN	RF	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. C
MFG. APPR.		D3179	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		LITTER TIE DOWN BRACKET	NTS
DATE	08.11.07	COPYRIGHT © 1995 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT FOR BE USED IN OR FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE EXPRESS WRITTEN PERMISSION FROM DART AEROSPACE LTD.			

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